Work Order ID 73534

Thursday, September 01, 2011 3:10:01 PM

Item ID:

D3189-1

Revision ID:

Item Name:

Chafing Shield

Start Date:

9/1/2011

QC:

Start Qty: 20.00

Required Date: 9/9/2011

Req'd Qty: 20.00



Accept



Setup Start



Stop

Reject

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date:

Date:

Tool # Plan

Code

Cust Item ID:

Customer:

Tool ID

Run Start

Reject

Qty

Stop

Insp.

Stamp

Sequence ID/ **Work Center ID** Operation Description

Draw Nbr D3189

Rev B

100

Waterjet

FLOW CNC Waterjet

364 620

SHEAR

Revision Nbr

Memo

1-Cut as per Dwg

Dwg Rev: Prog Rev: 0.00

0.00

B11-9-19

Accept

Qty

2-Deburr if necessary

103

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

1811-9-19

Page 2

Thursday, September 01, 2011 3:10:01 PM

Item ID:

D3189-1

Accept

Setup Start

Revision ID:

Item Name:

Required Date: 9/9/2011

Chafing Shield

Start Date:

9/1/2011

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Number Stamp

110

Small Fab Small Fab

Small Fab

Memo

Memo

0.00

0.00

1-Deburr & Grind Rads as per Dwg D3189

2-Roll as per Dwg D3189

3-Apply a thin layer of Pro Seal on inside surface of chafing shield 0.03" - 0.06"

thick as per DSI9549 and DEO D412-664-243.

120

Quality Control

OC5- Inspect part completeness to step on W/O

D 11/09/24

Dart Ae	rospace	e Ltd									• ,
W/O:			•	V	VORK ORDER C	HANGES					
DATE STEP			PROCEDURE CHANGE			Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
										·	
								<u></u>]
Part No):		PAR #:	_ Fault Ca	itegory:	NO	CR: Yes	No DQ	A:	Date: _	
	F	lesolu	tion:	_ Disposi	tion:	Q,	A: N/C C	osed:		Date: _	
NCR:			W	ORK OR	DER NON-CON	ORMANC	E (NCF	₹)			
			Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approva
DATE	STEP		Section A	Initial Chief Eng	Action Desc Chief En	ription	Sign & Date	Sec	tion C	Chief Eng	QC inspect
										·	
	3										

Page 3

Thursday, September 01, 2011 3:10:01 PM

Item ID:

D3189-1

Accept



Setup Start



Revision ID:

Item Name:

Required Date: 9/9/2011

Chafing Shield

Start Date:

9/1/2011

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Date:

Stop

Sequence ID/

Work Center ID

130

Packaging

Memo

Operation Description

Identify as per dwg & Stock Location: X+ tube

Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

0.00

Packaging

140

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Ae	ospace	Ltd								*
W/O:			WC	ORK ORDER CH	ANGES					
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:								
NCR:				ER NON-CONFO						
		Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	otion 	Sign & Date	9 -	ion C	Chief Eng	QC inspector
						·				

Picklist Print

Thursday, September 01, 2011 3:09:58 PM

Work Order ID: 73534

Parent Item:

D3189-1

Parent Item Name: Chafing Shield



Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP B :05.08.22: No longer made in-house!]KJ/JLM()

IPP Rev:C 06-03-24 Rolling Now made in House JLM

IPP Rev:D 07-04-16 As per Rev B JLM 11.05.11 now made on waterjet DD verf:JLM IPP Rev:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Qty po Hand	er Kit Total Qty	Qty Issued	Date Status Issued	
M304S25GA		Purchased	No		100	sf		.32 6.736	342	> -	
								rk	11-9-19		

304/316 .020" Sheet

Location	Loc Qty	Loc Code	
MAT20	117.5		
117285	5.5		
118228	112		Sec811

Dart Ae	rospace	Ltd							•
W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP		PROCEDURE CHANGE				te Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No):	PAR #	: Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	Disposition	າ:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCI	₹)			
DATE	0750	Description of N	C	Corrective Action Section		Verifi	cation	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspect

DART AEROSPACE LTD	Work Order:	7354
Description: Chafing Shield	Part Number:	D3189-1
Inspection Dwg: D3189 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		A -4	T		ТТ	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.13	+/-0.030	4.129	×		V 4307	1
11.25	+/-0.030	11.756	7		Prouzes	
0.020	+/-0.010	,०५३	×		V	
			1			
			<u> </u>			and the second s
			,			
						,
			<u> </u>			
	-					

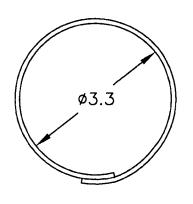
	Approval:	Preliminary A	udited by:	B	ured by:	Meas
	Date:		Date: ILLOGIG	11-9-19	Date:	
Approyed/	evised,by	Re		Change	Date	Rev
(61		KJ		New Issue	11.06.21	Α



DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B APPROVED D3189 SHEET 1 OF 2 TITLE DATE SCALE 07.01.05 CHAFING SHIELD 1:2 Α 03.05.08 **NEW ISSUE** В 07.01.05 ADD -3

RELEASED

11.25		
	. ,	4.13
D3189-1 FLAT PATTERN	,	R0.063 (TYP)



D3189-1 ROLLING DETAIL
NOT TO SCALE

W 0 23534

D3189-1 CHAFING SHIELD

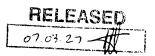
- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

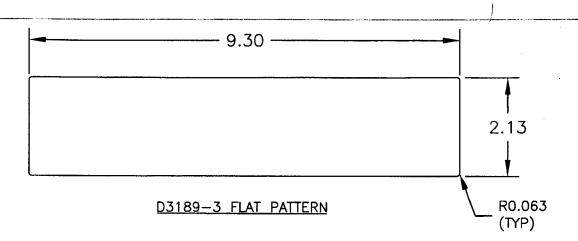
Copyright © 2003 by DART AEROSPACE LTD

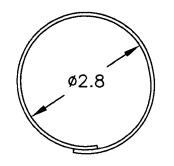
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USE!) FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN P	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED 44	APPROVED //	DRAWING NO.	REV. B
 		D3189	SHEET 2 OF 2
DATE		TITLE	SCALE
07.01.05		CHAFING SHIELD	1:2







D3189-3 ROLLING DETAIL NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.